



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

S002660

D206-642-341BL
Job Sheet 166601



Part No: D206-642-341BL

Job Qty: 1 ea

Part Name: Replacement Skidtube (Fits LH or RH)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/12/17

Job Tracking No:

Due Date: 10/27/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV F(DEO) IPP Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC IPP rev K 10.08.03 chg ms27039-1-08 for "C" type EC ver: DD IPP Rev: L 12.11.22 now swage per ecn12-679 DD ver: JLM IPP Rev: M 14.04.25 ECN14-520 DD ver: JLM IPP REV: N 15.10.09 ADDED BL DD VERF: JLM IPP REV: O 16.01.22 PAR16-484 DD VERF: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea	10/26/17	0.00	0.00	Start up container	
400	DC	1 pcs	10/26/17	0.00	0.00	DC	
110	Skidtubes	1 pcs	10/26/17	0.00	1.58	Skidtubes	
115	QC	1 pcs	10/26/17	0.00	0.00	QC5	
116	QC	1 pcs	10/26/17	0.00	0.00	QC9	
120	HandFinish	1 pcs	10/26/17	0.00	1.17	HandFinish1	2017/10/23 JSC
125	QC	1 pcs	10/26/17	0.00	0.00	QC7	
130	Skidtubes	1 pcs	10/26/17	0.00	1.58	Skidtubes	
140	QC	1 pcs	10/26/17	0.00	0.00	QC5	
150	Skidtubes	1 pcs	10/26/17	0.00	1.58	Skidtubes	
180	QC	1 pcs	10/26/17	0.00	0.00	QC5	
190	HandFinish	1 pcs	10/26/17	0.00	1.17	HandFinish2	JSC
200	Purchasing	1 pcs	10/26/17	0.00	0.00	Purchasing	DAS
205	QC	1 pcs	10/26/17	0.00	0.00	QC6	DAS 38
210	QC	1 pcs	10/26/17	0.00	0.00	QC14	38 3-89
220	HandFinish	1 pcs	10/27/17	0.00	1.17	HandFinish4	BR 9-89 DAS
230	QC	1 pcs	10/27/17	0.00	0.00	QC3	DAS 38
240	QC	1 pcs	10/27/17	0.00	0.00	QC5	38 9-89
250	Packaging	1 pcs	10/27/17	0.00	0.00	Packaging3	9-89
260	QC21-FG	1 Ea	10/27/17	0.00	0.00	QC21	MCD 17-11-1

Part Op 100 - Photocopy bluefile and create labels per PPP D206-642-341 CHG005

Descriptions: 110 - 1-Deburr Fwd edge of tube 2-Scribe "Identify Batch Number" 3-Remove ridge on inside of Fwd edge of tube as per Dwg D2650 4-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required. A/R Aluminum Rod 136158 m 137133 5-Grind weld flush to cap on top surface only. 6-Cut aft end to length as per dwg D2650 7-Drill pilot holes using drill Jig DT8168A (A, & B) and DT8025. 8-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297". 9-Open Aft Cap Hole using #6 Drill Bit 10-Open holes for Tow Ring to Ø 0.625" as per Dwg D2650, D2650-5 Drilling Detail 11-Remove inner indexing ridge on aft end of skidtubes per Dwg D2650 12- Ream holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid) 13-Deburr.

130 - 1- Bond D2654-5 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs. cure time before cutting Start Date: 17/10/23 Time: 16.00 Finish Date: 17/10/23 Time: 16.15 A/R Sikaflex-291 M138535

Sikaflex expiry date: 2018-04-21

150 - 1- Insert D4720-1 Spacer. Swage to 0.313" X 0.75" DP per QSI 002. Trim and grind flush per QSI 002

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date : _____ Step #: _____

MRB (QSI042) Approval

Description Work Order I

Job No: 166601
Mfg Date: 10/26/17

HandFinish

D206-642-341BL

PART NO:
Revision:
Operation:
Quantity:
Change No:

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval



Replacement Skid tube (Fits LH or RH)



Root Cause	
Environment	☐
Design	☐
Doc/Data	☐
Equip/Tooling	☐
Handling/Pre	☐
Material	☐
Internal Transport	☐
Tribal Knowledge	☐
LOA	☐
Substation	☐
Past Expiry Date	☐
Misidentified	☐
No Re-verification	☐
Operator	☐
Offset/Setup	☐
Supplier	☐
Training	☐
Use for Testing	☐
Poor Information	☐
Rushing	☐
Product Improvement	☐
Process Improvement	☐
Manufacturing Process	☐
Past Due	☐

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1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Pres
Ben
Cent
Crac
Crim
Cuffs
Crushing
Heat Treat
Wave/Twist in Tube
Marks/Chatter

Inspection incomplete/Unqualified
Contamination
Countersink
Cut Too Short
Instructions Incomplete/Unclear
Drill Holes

Wrong Stock Pulled
Out of Sequence
Off-set
Mislabeled
Fit/Function
Misaligned/off center

Positioned Wrong
Outside Dimensions
Over/Under tolerance
Part Incorrect
Part Lost/Missing
Part Moved
Drawing
Finish
Misread
Turning Sequence

OTHER :

200 - ISSUE PO 38152 ***MASK ALL SADDLE AND GROUND HANDLING ATTACHMENT HOLES AS PER PAR16-484*** Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs. PRIME: Start Time: _____ Finish Time: _____ PAINT: DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____

220 - 1-Install inserts & wearpads as per dwg D2022. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. A/R Sikaflex-291 137506 Sikaflex expiry date: 17-11 2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive 3-Install MS27039-4-06 Screw 4-Inspect for foreign object per QSI 024 5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive A/R Sikaflex-291 137506 Sikaflex expiry date: 17-11 6- Install D2680-041 Nut Plate as per Dwg D2650 7-Wing Walk as per Dwg D2650-5 and QSI 005 4.4 Batch: 138273.
250 - Identify and pack for shipping as per PPP D206-642-341 Location:FG083

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2620 <u>8164474</u>	1	30	0	0
	D2647 <u>8163996</u>	1	41	0	0
	D2654-5 <u>8164376</u>	1	3	0	0
150-Skidtubes	D4720-1 <u>8163757</u>	19	590	0	0
220-HandFinish	ALS4-1032-130	54	120	0	0
	CCR264SS3-3	2	298	0	0
	CR3212-4-03	2	249	0	0
	D2646BL	1	14	0	0
	D2651-1BL	14	521	0	0
	D2651-3	14	544	0	0
	D2680-041	1	77	0	0
	D3537-1	6	107	0	0
	D3537-3	1	19	0	0
	D4956-11	1	20	0	0
	D4956-23	1	15	0	0
	D4956-35	1	19	0	0
	MS27039-1-08	2	215	0	0
	MS27039-4-06	1	88	0	0
	MS27039C1-08	54	171	0	0
	NAS1149C0332R	54	2,674	0	0
	NAS1149D0332J	2	1,532	0	0
	NAS1149D0463J	1	1,118	0	0

Part Specifications

Specifications could not be found.

Plex 10/12/17 10:11 AM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 16660115
OCT 12 2017

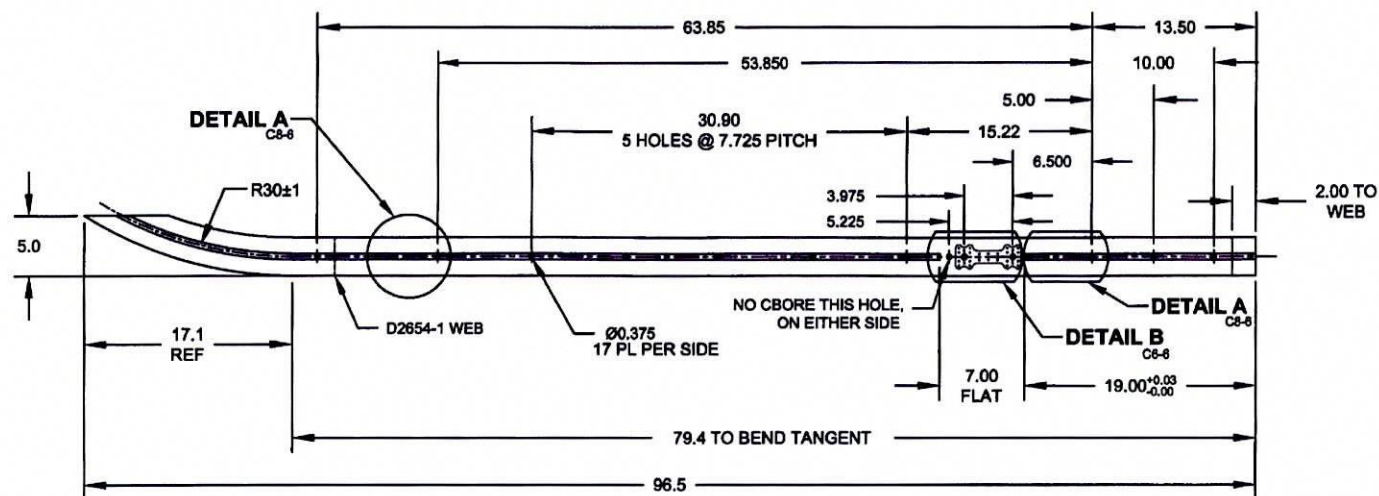
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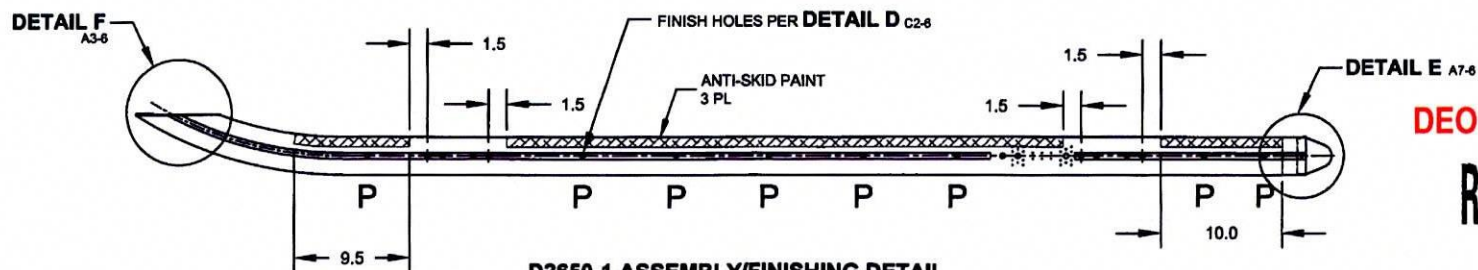
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCCRP. DE08136/8153/8163 MOD GROUND HANDLING ON D2650-1/3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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D2650-1 BENDING/DRILLING DETAIL

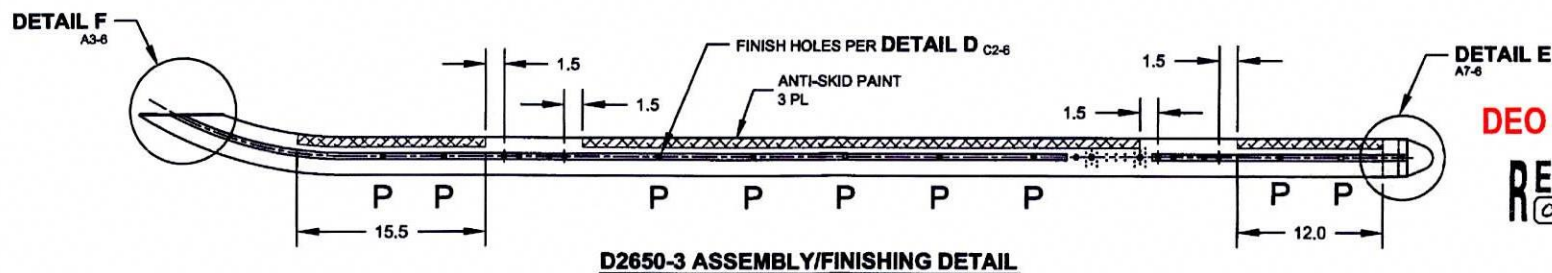
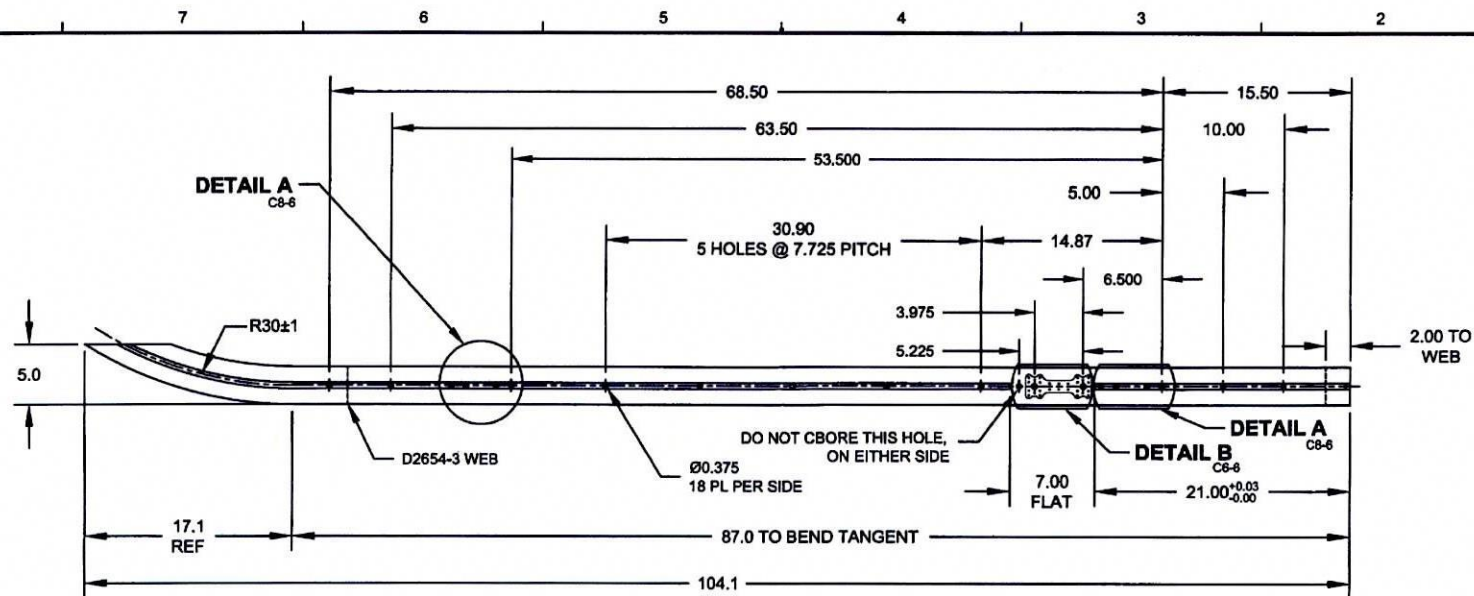


D2650-1 ASSEMBLY/FINISHING DETAIL

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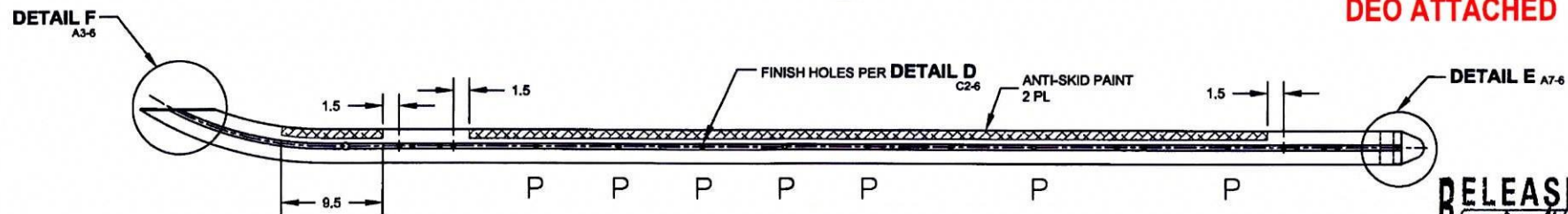
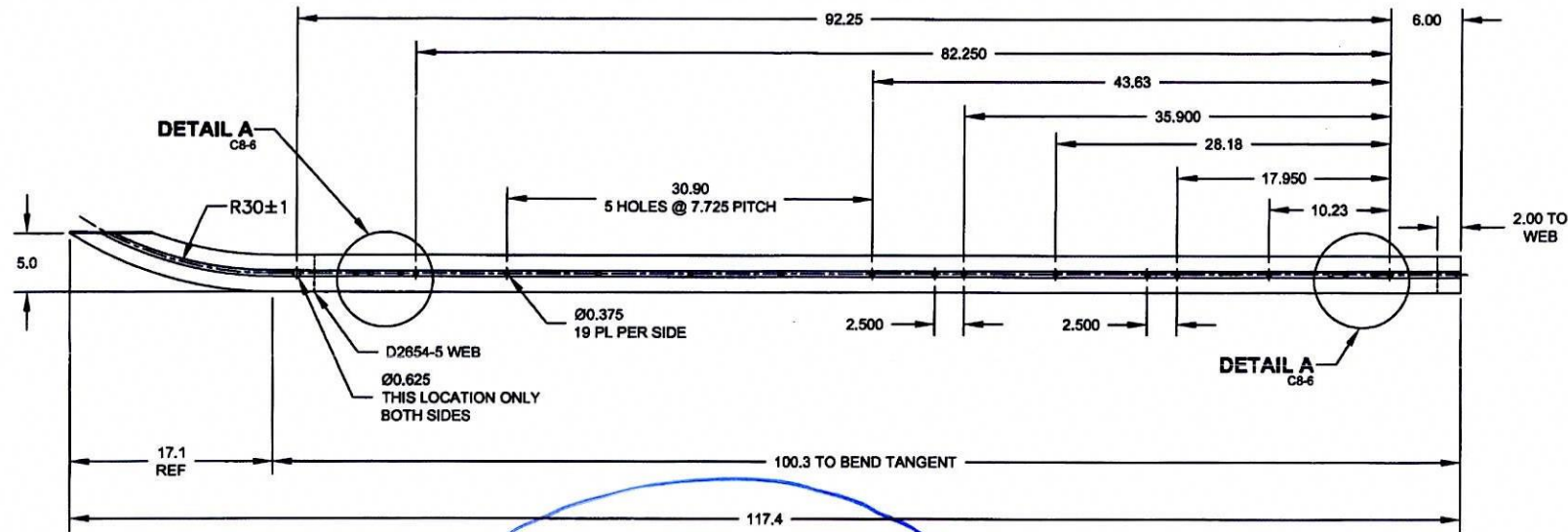
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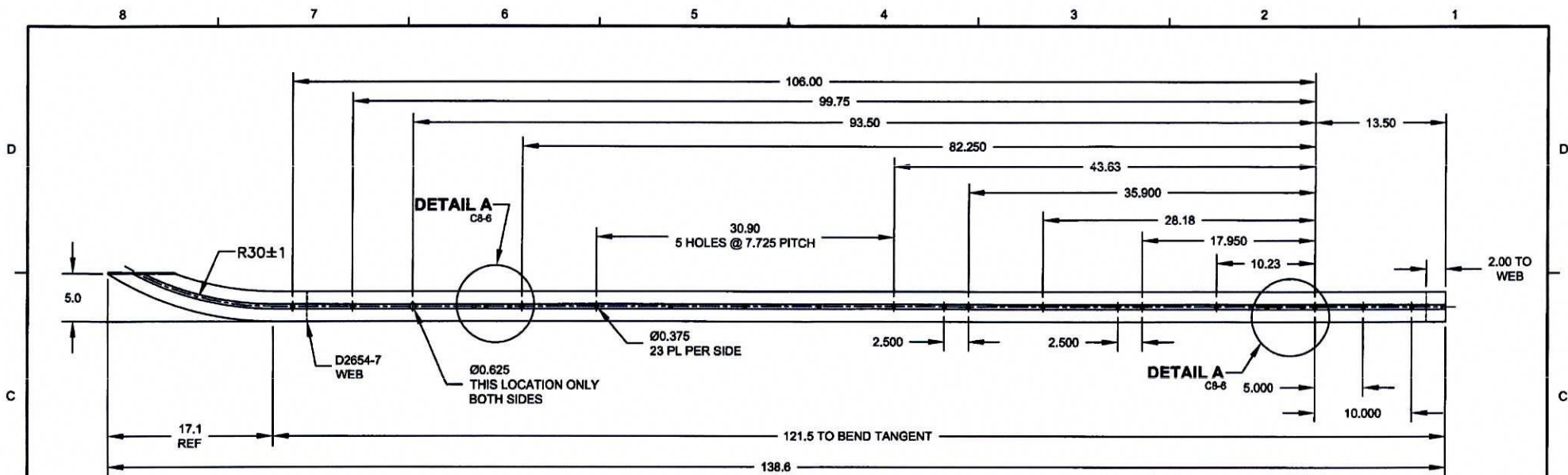
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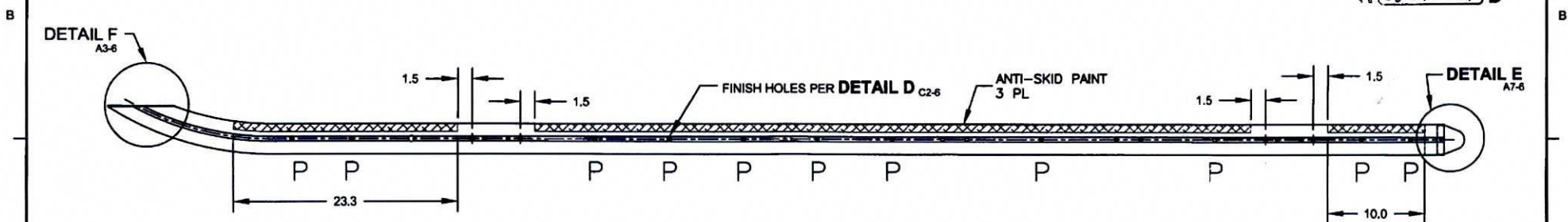
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D2650-7 BENDING/DRILL DETAIL

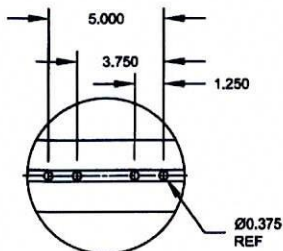
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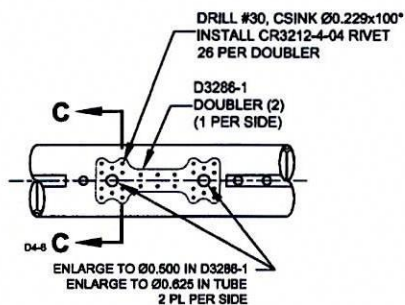


D2650-7 ASSEMBLY/FINISHING DETAIL

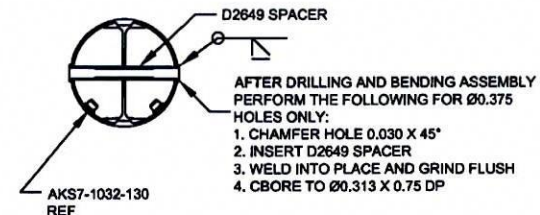
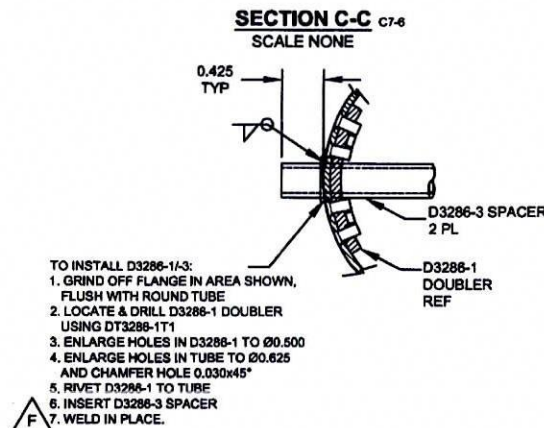
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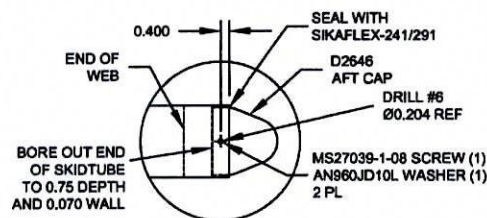
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D7-2
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C2-4
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C2-5
D8-5



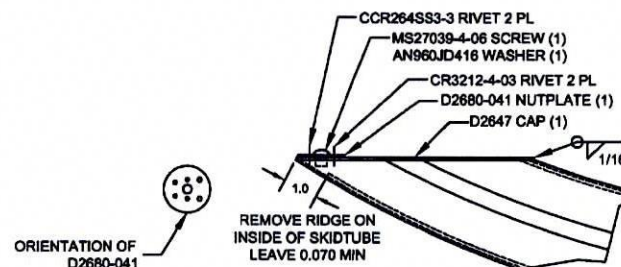
DETAIL B
SCALE 2X
C3-2
C3-3



DETAIL D
FOR Ø0.375 HOLES ONLY
SCALE 3X
B4-2
B4-3
B4-4
B4-5



DETAIL E
SCALE 2X
B2-2
B2-3
B1-4
B1-5



DETAIL F
SCALE NONE
B5-2
B5-3
B5-4
B5-5

- DETAIL F NOTES:**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2647 (TRIM AS NECESSARY)
 4. WELD D2647 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D2680-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

RELEASED
08-09-22-19

DEO ATTACHED

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
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DRAWING NO. D2650	TITLE 206/407 SKIDTUBE ASSEMBLIES	REV. F	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2650-F-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>[Signature]</i>	CHECKED A.P.	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 12.10.12	DATE 12.10.22	DATE 12.10.22	DATE 12.10.22		DATE 12.10.22		

PURPOSE:

CHANGE C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

IS:

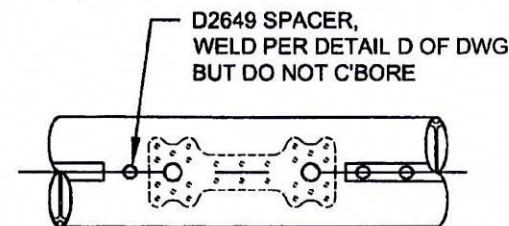
QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
-1	-3	-5	-7		
1	1	0	0	D2649	CROSS BOLT SPACER
16	17	19	23	D4720-1	SPACER

WAS:

17	18	19	23	D2649	CROSS BOLT SPACER
----	----	----	----	-------	-------------------

ADD DETAIL G BELOW, WHICH IS THE SAME SECTION VIEW AS DETAIL D OF DWG.

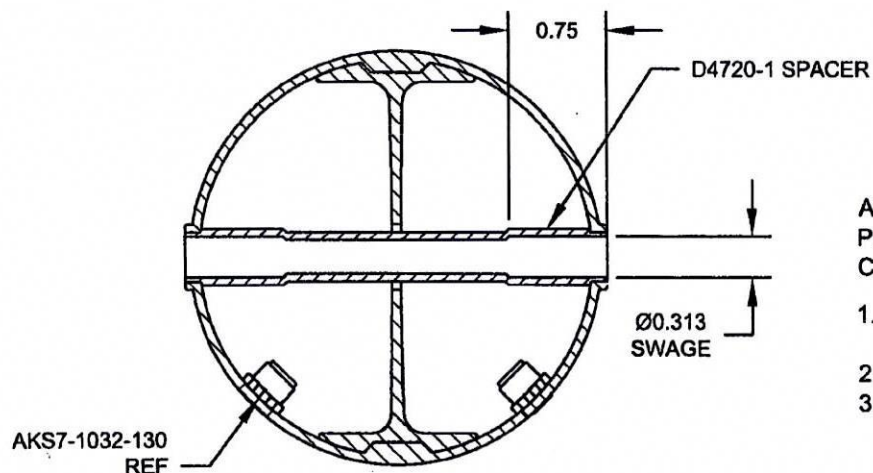
C'BORED HOLES ARE NOW SWAGED PER DETAIL G BELOW. FOR THE Ø0.375 HOLE THAT IS NOT C'BORED, WELD PER DETAIL D OF DWG (SEE AMENDED DETAIL B FOR REFERENCE).



DETAIL B

AMENDMENT TO DETAIL B
NOT TO SCALE

RELEASED
2012-11-16
[Signature]



DETAIL G

FOR Ø0.375 HOLES ONLY
FOR HOLES THAT ARE CURRENTLY C'BORED ONLY
NOT TO SCALE

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES THAT ARE
CURRENTLY C'BORED:

1. INSERT D4720-1 SPACER, 16 PL (-1) OR 17 PL (-3)
OR 19 PL (-5) OR 23 PL (-7)
2. SWAGE TO Ø0.313 X 0.75 DP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO038152

Supplier: ATE003-VC
Atelier Debosselage
358 Principale
Calumet
QC
J0V 1B0 Canada
Phone: 819 242 5633

PO No: PO038152
PO Date: 10/26/17
Due Date: 10/27/17
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Lavoie, Chantal
Phone: clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Rev	Description	Item Tax	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	166609	D206-642-341BL	-	prime and paint delfleet blue		Firmed	10/27/17	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
2	166598	D206-642-341BL	-			Firmed	10/27/17	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
3	166601	D206-642-341BL	-			Firmed	10/27/17	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
4	166607	D206-642-341BL	-			Firmed	10/27/17	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
5	166596	D206-642-341BL	-			Firmed	10/27/17	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
6	166588	D206-642-341BL	-			Firmed	10/27/17	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
7	166590	D206-642-341BL	-			Firmed	10/27/17	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
8	166604	D206-642-341BL	-			Firmed	10/27/17	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00

Grand Total: \$1,800.00

Order Notes

DWG REV F(DEO) IPP Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC
Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC IPP rev K 10.08.03 chg ms27039-1-08 for "C" type EC verf: DD IPP Rev: L
12.11.22 now swage per ecn12-679 DD verf: JLM IPP Rev: M 14.04.25 ECN14-520 DD verf: JLM IPP REV: N 15.10.09 ADDED BL DD
VERF: JLM IPP REV: O 16.01.22 PAR16-484 DD VERF: JLM

DWG REV F(DEO) IPP Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC
Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC IPP rev K 10.08.03 chg ms27039-1-08 for "C" type EC verf: DD IPP Rev: L
12.11.22 now swage per ecn12-679 DD verf: JLM IPP Rev: M 14.04.25 ECN14-520 DD verf: JLM IPP REV: N 15.10.09 ADDED BL DD
VERF: JLM IPP REV: O 16.01.22 PAR16-484 DD VERF: JLM